

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016567**Date Inspected:** 28-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY- 6

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint SP3140A-001-006,007. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

Flux Cored Arc Welding (FCAW) of weld joint FB3169-001-019. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Li Jia. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4b-F.

FCAW of weld joint FB3169-002-022. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Li Jia. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4b-F.

ZPMC personnel heat straightening OBG member identified as FB4101A. Distortion appeared to be caused by

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welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Shu Yang Hua was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 9150.

BAY- 7

SMAW Tack welding of weld joint DP3181-001-001,002. Welder is identified as 046819. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

FCAW of weld joint SP3119B-001-036,037. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW of weld joint SP3119B-001-044,045. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW of weld joint SP3122A-001-077. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F-2.

BAY- 8

FCAW of weld joint BK004A4-061-014. Welder is identified as 046706. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

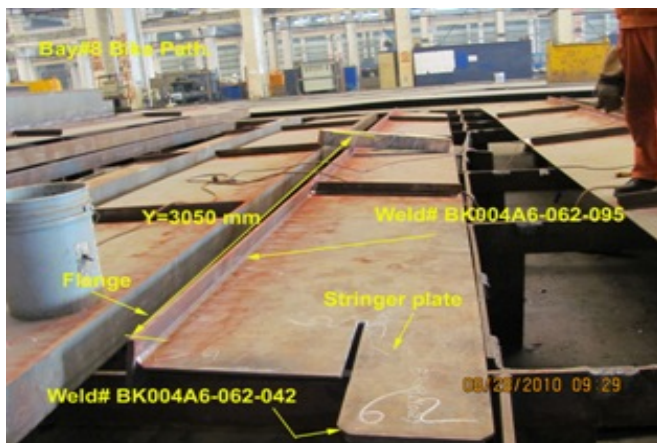
FCAW of weld joint BK004A4-061-015. Welder is identified as 046706. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

ZPMC Quality Control (QC) MT Technician was performing Magnetic Particle Testing (MT) for the Bike Path weld joint identified as BK004A6-062-095. This QA Randomly witnessed the MT. During random witness of MT this QA observed ZPMC QC MT Technician found one (1) longitudinal linear crack measuring approximately 20 mm in length. The "Y" location for this crack is 3050 mm from the nearest end of the weld. This QA informed to ZPMC QC Certified Welding Inspector(CWI) identified as Mr.Liu Fa Wen and American Bridge/Fluor (AB/F) QA Inspector Mr. Liu Hua Jie. Mr.Liu Fa Wen and Mr. Liu Hua Jie informed this QA that the Crack would be corrected in a manner compliant with the contract documents. Refer the attached photos for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer